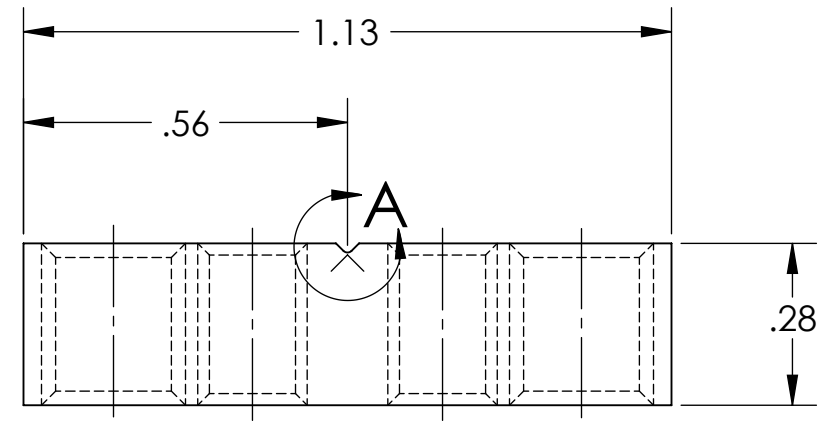
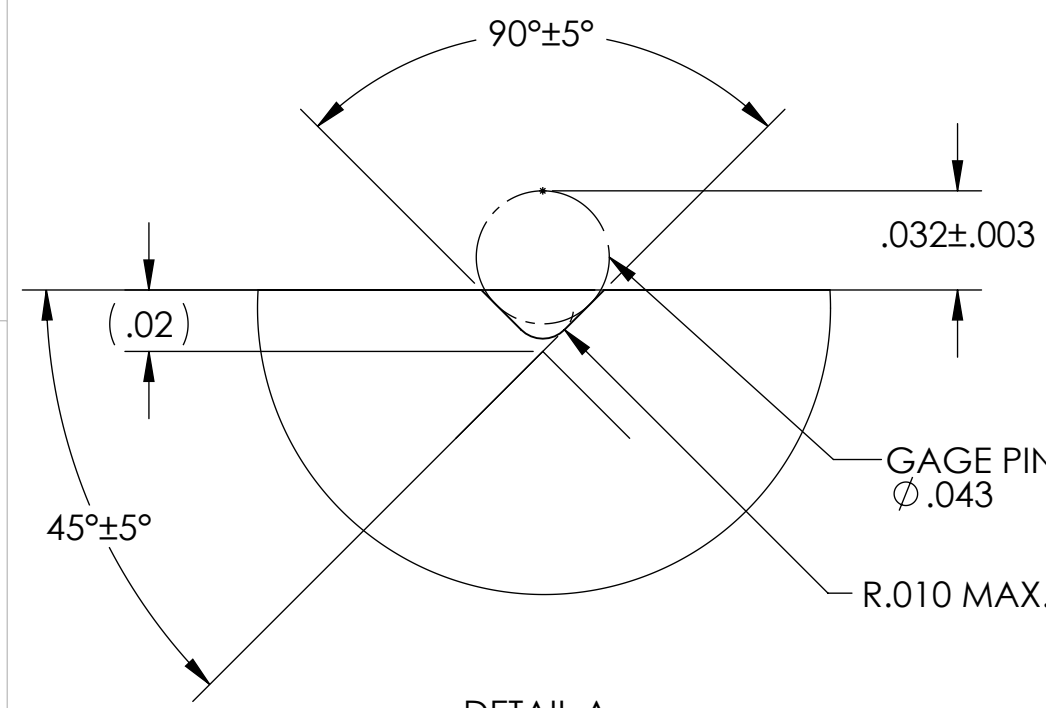
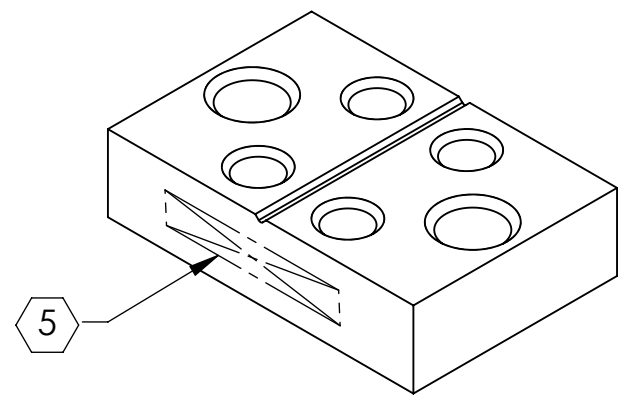
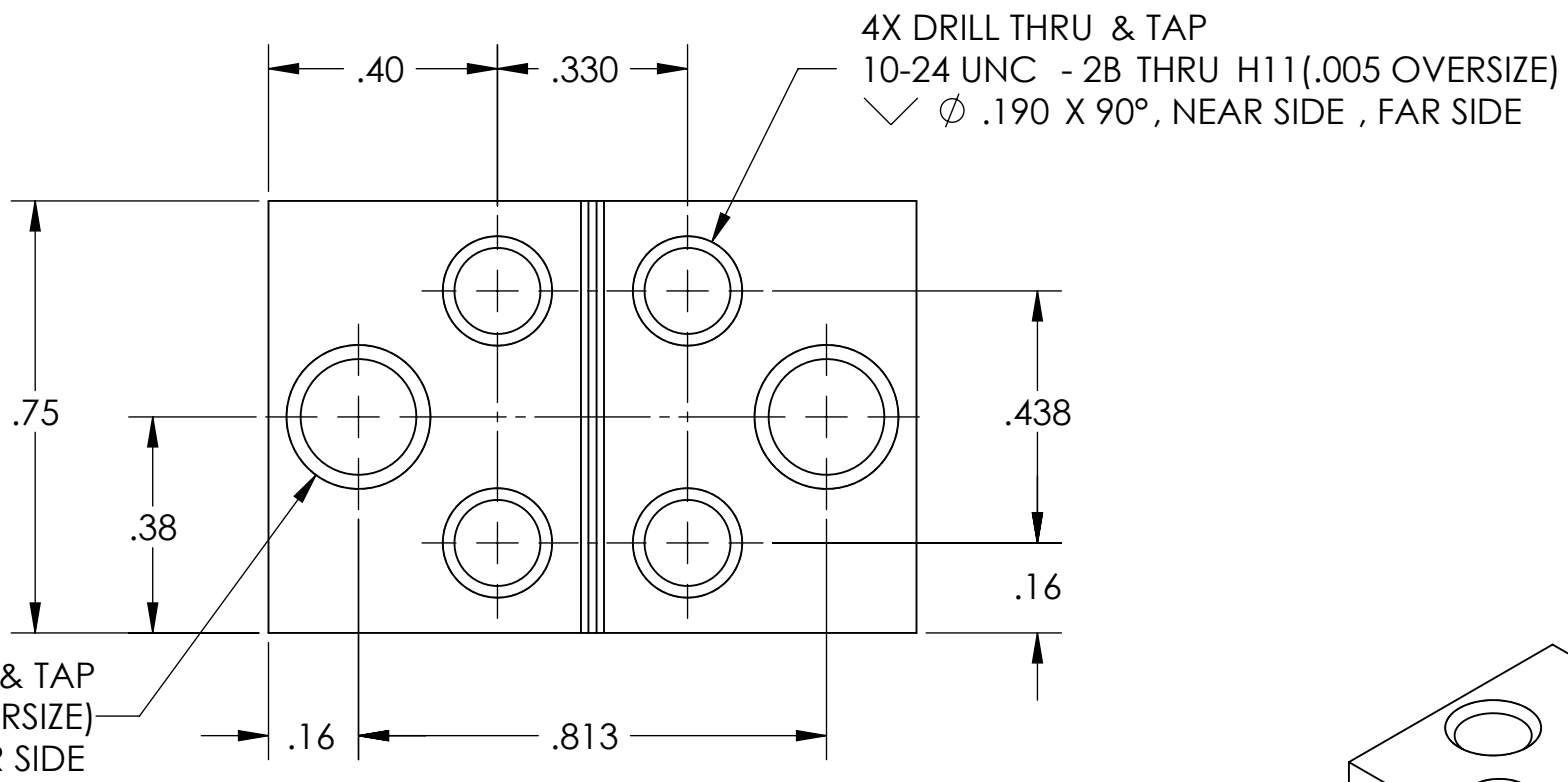


D1002240 aLIGO TMS Tele Wire Clamp Base, PART PDM REV: X-025, DRAWING PDM REV: X-003

REV.	DATE	DCN #	BOM #
v1	22 JUN 2011	E1100351	E1100626
v2	26 MAR 2012	E1200317-x0	-
-	-	-	-

- NOTES CONTINUED:**
- 5 SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX
  - 6. APPROXIMATE WEIGHT = 0.057 LBS
  - 7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFER TO LIGO-E0900364
  - 8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
  - 9. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
  - 10 SURFACE FINISH ON ALL PART, TO BE 63  $\mu$ inch Ra EXCEPT WHERE SPECIFIED.



DETAIL A  
SCALE 16:1  
NO BURRS AROUND GROOVE

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES TOLERANCES: .XX ± .01 .XXX ± .005 ANGULAR ± 1.0°				1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, .005-.015, FOR MACHINED PARTS. ROUND ALL EDGES APPROXIMATELY R.02 FOR SHEET METAL PARTS. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		aLIGO TMS TELESCOPE WIRE CLAMP BASE	
MATERIAL		FINISH		SYSTEM		SUB-SYSTEM	
304 SSSL		63 $\mu$ inch Ra		ADVANCED LIGO		AOS	
NEXT ASSY				DESIGNER		DATE	
D1101162				K. MAILAND		18 AUG 2010	
				DRAFTER		SIZE	
				J. TERRAZAS		DWG. NO.	
				CHECKER		B	
				SEE DCC		D1002240	
				APPROVAL		REV.	
				SEE DCC		v2	
				SCALE: 4:1		PROJECTION:	
				SHEET 1 OF 1			